

Work Order ID 84870-1

May-29-12 1:00:10 PM

84870

Page 1

Item ID: D3564-9

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearshoe

Start Date: 29/05/2012 Start Qty: 25.00 *25*

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 25.00 *25*

Customer:

Reference:

Approvals: Process Plan: MJS

Date: 12/05/30 Tooling:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3564

Rev D

(35)

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

B12-6-3

FLOW CNC Waterjet

1-Cut as per Dwg D3564 ***** (D3564-1F) ***** Dwg Rev: D Prog

304.063

Rev: D 2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

B12-6-3

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

25

12-06-07

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84870

May-29-12 1:00:10 PM

84870

Page 2

Item ID: D3564-9 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearshoe
 Start Date: 29/05/2012 Start Qty: 25.00 ***25*** Cust Item ID:
 Required Date: 16/07/2012 Req'd Qty: 25.00 ***25*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	NC BRAKE	0.00				25			SP 12/06/08
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130

Brake NC

Brake NC

Memo

0.00

Deburr if necessary Form on Brake as per Dwg D3564 using Jigs DT 8129 and DT 8155 Form Joggle as per Dwg D3564 on brake using Jig DT 8157

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Quality Control

Memo

0.00

Ensure joggle as per dwg D3429

150

Large Fab

0.00

150

Large Fab

Large Fab

Memo

0.00

Qty Description Batch A/R 2059B Hardcoat
 m 122030 Weld hardcoat as per Dwg D3564

Locates 25

113

ME

12-06-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 3

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearshoe

Start Date: 29/05/2012 Start Qty: 25.00

25

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 25.00

25

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

160

QC

Memo

0.00

Quality Control

13x *Pl 12.06.22*

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

13x *W 12.06.22*

180

Grey Sandtex(Ref:4,3,5,6) per QSI005 4.3

0.00

180

Powdercoat

Memo

0.00

Powder Coating

START TIME: *9:55* OVEN TEMPERATURE:
320° FINISH TIME: *9:05*

13 *φ* *12.06.22*

W/O:		WORK ORDER CHANGES					
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Work Order ID 84870

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84870

Page 4

Item ID: D3564-9

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearshoe

Start Date: 29/05/2012 Start Qty: 25.00

25

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 25.00

25

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC3- Inspect Part Finish

0.00

190

QC

Memo

0.00

Quality Control

13 x d 44 12/06/25

200

Identify as per dwg & Stock Location: FP1

0.00

200

Packaging

Memo

0.00

Packaging

13- d 44 12/06-25.

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

12/06/25 d

MF
12-06-25

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NOTE: Date & initial all entries

Picklist Print

May-29-12 1:00:13 PM

Page 1

Work Order ID: 84870

84870

Parent Item: D3564-9

D3564-9

Parent Item Name: Wearshoe

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 25.00

Required Qty: 25.00

Comments: IPP Rev:A New Issue 07-03-08 ec
 IPP Rev:B As per Rev C 07-07-09 JLM
 IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	SF	271.9720	1.41	37.10526			

M304S16GA

**

304/316 Sheet .063

1812-6-3

Location

Loc Qty

Loc Code

MAT020

271.972

121626

143.972

121889

128

121626

25

W/O:		WORK ORDER CHANGES					
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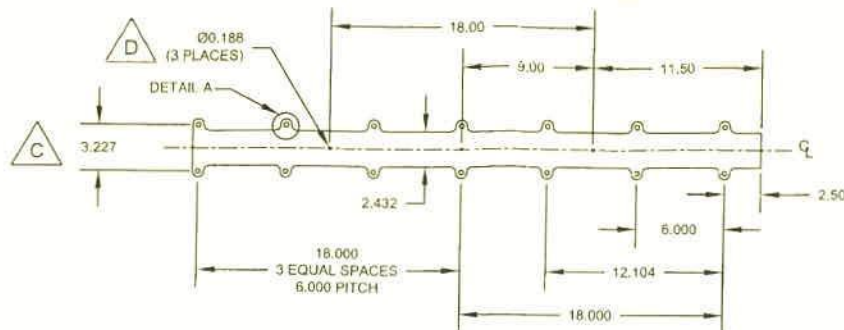
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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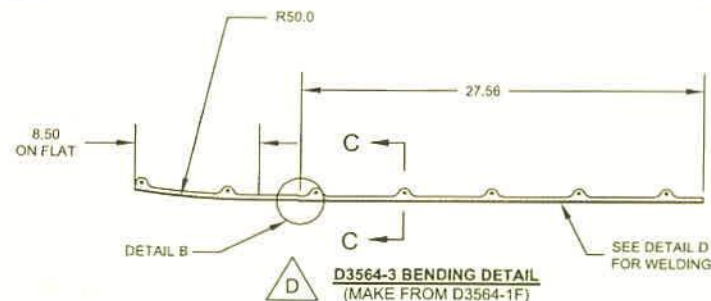
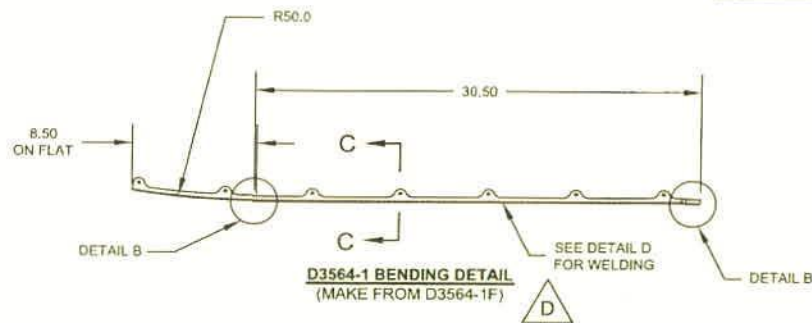
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NOTE: Date & initial all entries



D3564-1F FLAT PATTERN



RELEASED

07.07.04

UNDER REVIEW
Fresh change
OK 9/11/28

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84870 MLJ
12/05/30

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANOX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE: CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1; PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. D
D3564 SHEET 1 OF 3
TITLE SCALE
WEARSHOE 1/8

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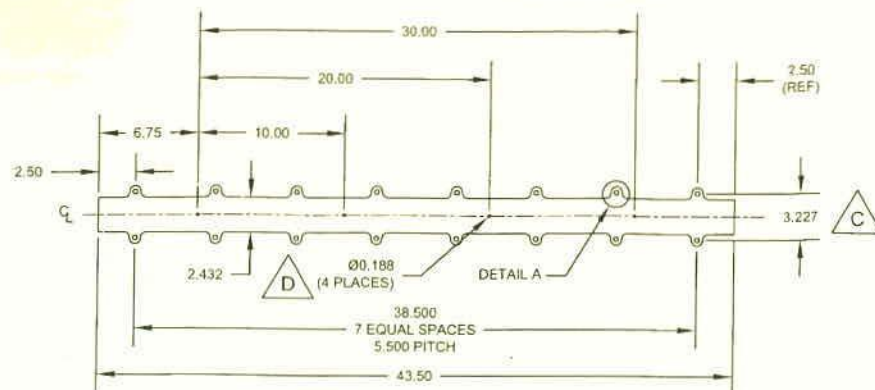
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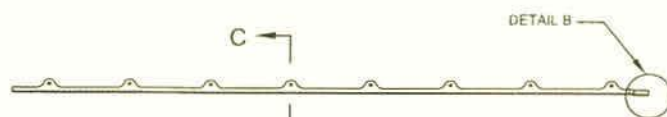
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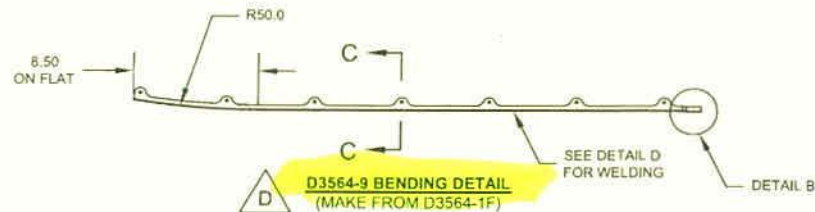
NOTE: Date & initial all entries



D3564-5F FLAT PATTERN



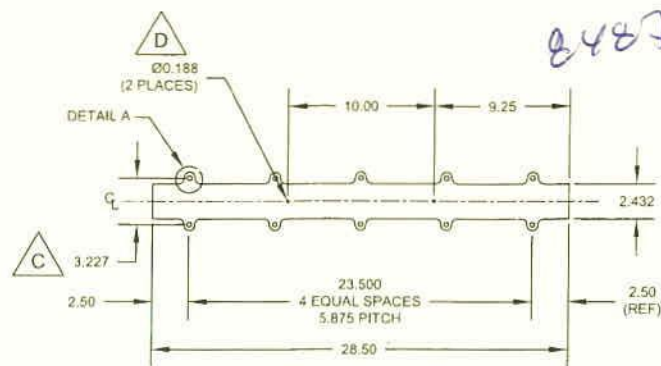
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



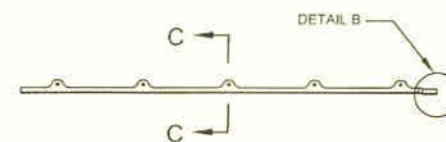
D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)

SEE DETAIL D
FOR WELDING

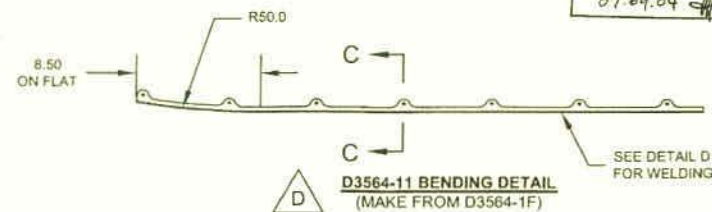
DETAIL B



D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED

07.09.04

UNDER REVIEW

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D3564	SHEET 2 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
DATE	07.08.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD	

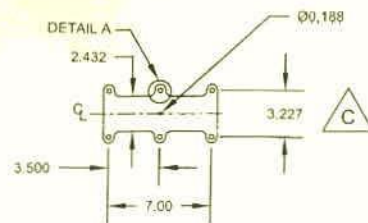
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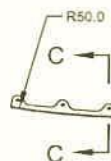
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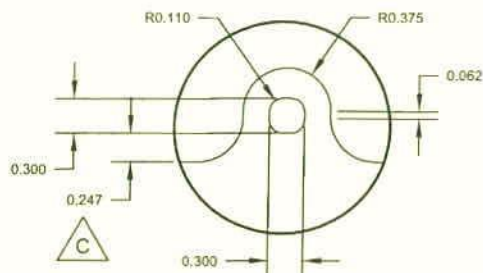
NOTE: Date & initial all entries



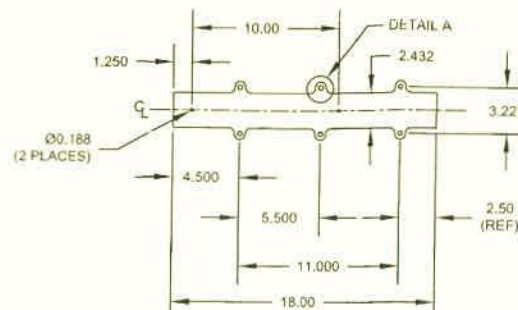
D3564-13F FLAT PATTERN



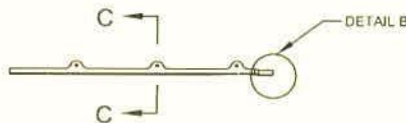
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



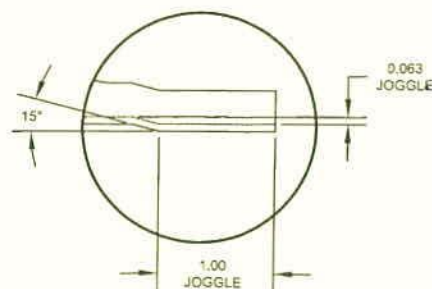
DETAIL A
SCALE 1:1



D3564-15F FLAT PATTERN



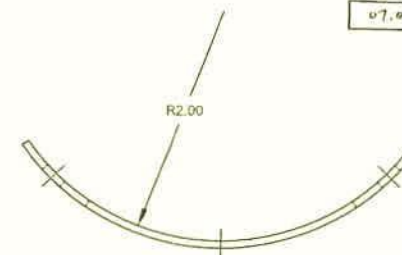
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



DETAIL B
SCALE 1:1



DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



SECTION C-C
SCALE 1:1

RELEASED

07.09.04

UNDER REVIEW
07.11.28

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	CB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO. D3564	REV. D
MFG. APPR.	PH	SHEET 3 OF 3	
APPROVED	PH	TITLE WEARSHOE	SCALE 1:8
DE APPR.	PH	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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